

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021333**Date Inspected:** 02-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai**CWI Name:** Tian Lei, Liu Fa Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector R. Hernandez was present during the time noted above and conducted observations relative to the work being performed.

The QA Inspector randomly observed the following work in progress:

Bay Number 1

FCAW welding of complete joint penetration welds located on traveler rail component identified as 20TR2-037 weld no.(s) 011 & 20TR2-038 weld no.(s) 011. Welder is identified as welder no. 057795. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-P-2211-TC-U4b.

FCAW welding of complete joint penetration welds located on traveler rail component identified as 20TR2-037 weld no.(s) 011 & 20TR2-038 weld no.(s) 011. Welder is identified as welder no. 054467. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-P-2211-TC-U4b.

FCAW welding of complete joint penetration welds located on traveler rail component identified as 20TR2-037 weld no.(s) 011 & 20TR2-038 weld no.(s) 011. Welder is identified as welder no. 049769. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-P-2211-TC-U4b.

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FCAW welding of complete joint penetration welds located on traveler rail component identified as 20TR2-037 weld no.(s) 011 & 20TR2-038 weld no.(s) 011. Welder is identified as welder no. 215248. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-P-2211-TC-U4b.

This QA inspector performed VT of approximately 100% of the area previously tested and accepted by ZPMC Quality Control personnel. All components were as listed on NWIT notification no. 08425. The member(s) is/are identified as OBG Sub Assembly identified as noted below with the following weld no.(s):

1. SA3002A (miscellaneous platform)
2. SA3003A (miscellaneous ladder)

Performed verification VT for the component(s) identified as OBG Sub Assembly for components listed as SA3002A & SA3003A for miscellaneous platform and ladder, This QA inspector signed green tag #14428.

Bay Number 3

This inspector observed ZPMC QC personnel performing fit-up and bevel edge preparation of the following piece numbers for the component identified as SA8009 (Architectural Housing Shroud) piece no.(s) SP31208, Sp3122A, & SP3121A, SP3122C per welding detail WD371T & WD371S per joint detail CJP (TC-U4b-GF) a 45 degree angle.

This inspector conducted review of B-WR20112 for EP3017 weld no.(s) 049 & 074. These welds must be removed in order to conduct future heat straightening.

SMAW welding of complete joint penetration welds located on Architectural Housing component identified as AH3150 as identified on weld repair data sheet B-WR-20318 for repaired complete joint penetration welds identified as weld no.(s): 002 & 003. Welder is identified as welder no. 058102. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-345-SMAW-1G(1F)-repair.

Bay Number 8

SMAW welding of complete joint penetration welds located on Bike Path component identified as BK4ASD1-063 weld no.(s) 022, 023, 024, & 027. Welder is identified as welder no. 040673. The welding variables recorded by ZPMC QC identified as Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-P-2211-TC-U4b.

Unless otherwise noted above all items observed on this day appeared to be in general compliance with the applicable contract documents

Summary of Conversations:

Pertinent conversations are included in the body of the report.

Comments

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 1500-0042-02372, who represents the Office of Structural Materials for your project.

Inspected By:	Hernandez,Rene	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
